

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 1.28**WELDING INSPECTION REPORT****Resident Engineer:** Casey, William**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-026502**Date Inspected:** 10-Oct-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1530**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** Jobsite**CWI Name:** As noted below**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** SAS OBG**Summary of Items Observed:**

Quality Assurance Inspector (QA) Douglas Frey was at the American Bridge/Fluor (ABF) job site at Yerba Buena Island in California between the times noted above in order to monitor Quality Control functions and the in process work being performed by ABF personnel. The following items were observed:

1. 10W PP88 W4 Lifting Lug holes (Interior)
2. 12W 13W D2 Welding (Interior)
3. 12W 13W D1 Welding (Interior)
4. 9W PP72 Pipe Welding (Exterior)
5. 9W PP74 Pipe Welding (Exterior)

1. 10W PP88 W4 Lifting Lug holes (Interior)

The QA inspector observed the QC inspector identified as Sal Moreno perform Magnetic Particle Inspection on Lifting Lug Holes #1 and 3 at 10W PP88 on the interior of the OBG. The QA inspector verified that the proper procedure was utilized as well as correct technique. The testing found no indications and the QA inspector verified the findings and noted that the work appears to be in general conformance with the contract documents.

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2. 12W 13W D2 Welding (Interior)

The QA inspector randomly observed ABF welding operator Rory Hogan ID#3186 performing Submerged Arc Welding (SAW) on "D2" at 12W 13W of the OBG. The QA inspector observed the QC inspector identified as William Sherwood monitoring the welding to ensure the welding parameters were in compliance pertaining to ABF-WPS-D15-4042 B-1. The parameters were recorded as (A=560/V=32.5/TS=424/HI=2.57). The QA inspector made subsequent observations throughout the shift to monitor quality and noted that the work is in progress and appears to be in general conformance to the contract requirements.

3. 12W 13W D1 Welding (Interior)

The QA inspector randomly observed ABF welding operator Jeremy Dolman ID#5042 performing Flux Core Arc Welding with Gas (FCAW-G) on "D1" at 12W 13W of the OBG. The QA inspector observed the QC inspector identified as William Sherwood monitoring the welding to ensure the welding parameters were in compliance pertaining to ABF-WPS-D15-3040 A-1. The parameters were recorded as (A=252/V=23.2/TS=337/HI=1.04). The QA inspector made subsequent observations throughout the shift to monitor quality and noted that the work is in progress and the QA inspector noted that there was no form of continuous heat used during the welding operations.

4. 9W PP72 Pipe Welding (Exterior)

The QA inspector observed F.W. Spencer welder Curtis Jump ID# 7326 performing Shielded Metal Arc Welding (SMAW) in the 1G flat and 3G vertical positions on 2.5 and 4 inch schedule 80 pipe located at 9W PP72 weld #17/2.5/72/SW and weld #17/4/72/SW. The QA inspector verified the fit up of the joints and found it to be satisfactory. The QA inspector observed the QC inspector identified as Steve Jensen monitoring the welding to ensure the welding parameters were in compliance pertaining to WPS-1-12-1 Revision 2 (1.12). The welder was observed implementing 6010 electrodes in the root pass with the balance using 7018 electrodes. The QA inspector made subsequent observations throughout the shift to monitor quality and noted that the work appears to be in general conformance with the contract documents.

5. 9W PP74 Pipe Welding (Exterior)

The QA inspector observed F.W. Spencer welder Curtis Jump ID# 7326 performing Shielded Metal Arc Welding (SMAW) in the 1G flat and 3G vertical positions on 2.5 and 4 inch schedule 80 pipe located at 9W PP72 weld #18/2.5/74/SW and weld #18/4/74/SW. The QA inspector verified the fit up of the joints and found it to be satisfactory. The QA inspector observed the QC inspector identified as Steve Jensen monitoring the welding to ensure the welding parameters were in compliance pertaining to WPS-1-12-1 Revision 2 (1.12). The welder was observed implementing 6010 electrodes in the root pass with the balance using 7018 electrodes. The QA inspector made subsequent observations throughout the shift to monitor quality and noted that the work appears to be in general conformance with the contract documents.

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Summary of Conversations:

At the beginning the shift the QA inspector met with QC inspector William Sherwood and discussed the welders assignments and locations for the shift to include pending issues, ongoing work and required testing.



Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Nina Choy 510-385-5910 , who represents the Office of Structural Materials for your project.

Inspected By:	Frey,Doug	Quality Assurance Inspector
Reviewed By:	Levell,Bill	QA Reviewer
